Work Order ID 125533

Friday, October 10, 2014 7:14:44 AM

125533

Item ID: D4941-1L08 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Floor Protector, Fwd LH, (Clear)

Start Date: 10/10/2014 **Start Qty:** 4.00 *4*

Required Date: 10/15/2014 **Req'd Qty:** 4.00 *4*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** MLJ **Date:** 14-10-10 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**: D4941 / D									
100		0.00							DAS 07 9-89
100	HAND FINISHING THERMOFORMING					x4			
Thermoform	**Memo**	0.00							14/10/14
Thermoforming Machine	Cut Blanks								
105		0.00							DAS 07 9-89
105	Dry Material					x4			
HandThermo	**Memo**	0.00							14/10/16
Hand Finishing Thermoforming	Dry Sheet as per QSI022 POLYCARBONATE								

Temp: 245 deg. F

Time IN: 5:00 PM 6:00 AM OCT 15 2014

Time OUT: _____ Per DL

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Work Order ID 125533

Friday, October 10, 2014 7:14:44 AM

125533

Item ID: D4941-1L08 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Floor Protector, Fwd LH, (Clear) **Stop** *NS2*

Start Date: 10/10/2014 **Start Qty:** 4.00 *4*

Required Date: 10/15/2014 **Req'd Qty:** 4.00 *4*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
110	THERMOFORMING MACHINE				4	DAS 27 9-89			
Thermoform	**Memo**	0.00							
Thermoforming Machine	Thermoform as per Dwg. D4941 and Folio FTA 158								
	Dwg. Rev. E								
	Folio Rev. E								
130		0.00							DAS 07 9-89
130	HAND FINISHING THERMOFORMING					x4			
Thermoform	**Memo**	0.00							14/10/16.
Thermoforming Machine	Trim to Finished Dimensions								
140	QC2- Inspect parts off machine FAI/FAIB	0.00							DAS 07 9-89
140						x4			
QC	**Memo**	0.00							
Quality Control									

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

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DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
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Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

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☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

Work Order ID 125533

Friday, October 10, 2014 7:14:44 AM

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Item ID: D4941-1L08 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Floor Protector, Fwd LH, (Clear) **Stop** *NS2*

Start Date: 10/10/2014 **Start Qty:** 4.00 *4*

Required Date: 10/15/2014 **Req'd Qty:** 4.00 *4*

Reference:

Cust Item ID:

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00				4		14/10/17	DAS 9 9-89 DAS 51 9-89
150 QC Quality Control	**Memo**	0.00							
160		0.00							
160 Packaging Packaging	Packaging		PP121893			DAS 06 9-89 4			OCT 17 2014
	Memo	0.00							
170	QC21- Final Inspection - Work Order Release	0.00							
170 QC Quality Control	**Memo**	0.00						14/10/2014	MF 14-10-17

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
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Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

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☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Picklist Print

Friday, October 10, 2014 7:14:47 AM

Work Order ID: 125533 *125533*

Parent Item: D4941-1L08 *D4941-1L08*

Parent Item Name: Floor Protector, Fwd LH, (Clear)

Start Date: 10/10/2014 **Required Date:** 10/15/2014

Start Qty: 4.00 **Required Qty:** 4.00

Comments: IPP Rev. A New Issue 13/12/16 DL
Revised dimensions 14/02/12 DL
14/07/02 DL
IPP Rev. B
IPP Rev C Revised Dwg.
IPP Rev D Revised Dwg. 14/07/25 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.118-90318-08		Purchased	No			100	sf	2,366.508	4.875	20		DAS 27 9-09 14/10/16	
MLEXS.118-90318-08									**				
Lexan Sheet													

Location	Loc Qty	Loc Code
therm	2366.508	
113127	8	
m126994	2358.508	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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☐ Set-up
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☐ Wrong Stock Pulled
☐ Other _____

DART AEROSPACE LTD	Work Order:	125533
Description:	Part Number:	D4941-1L08
Inspection Dwg: D4941-1 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than N/A"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching				

Measured by:	~~DAS~~ 27 ~~9-89~~	Date:	14/10/16

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.0"	+/- .100	2.05"	✓			
0.8"	+/- .100	0.82"	✓			
0.4"	+/- .100	0.43"	✓			
7.2"	+/- .100	7.2"	✓			
9.6"	+/- .100	9.5"	✓			
13.5"	+/- .100	13.5"	✓			
0.070"	MIN	0.087"	✓			
0.030"	MIN	0.036"	✓			

Measured by:	DAS 07	Date:	14/10/16
Audited by:	~~DAS~~ 9 ~~9-89~~ DAS	Date:	14/10/17
Preliminary Approval:	51 9-89	Date:	

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

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DISPOSITION

Rework ☐
Scrap ☐
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Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
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Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
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Operator	☐									
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FAULT CATEGORY

Landing Gear

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General

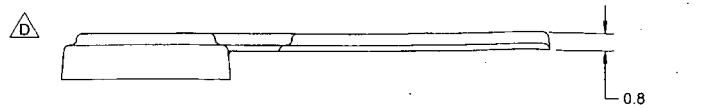
☐ Bend
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☐ Fit/Function

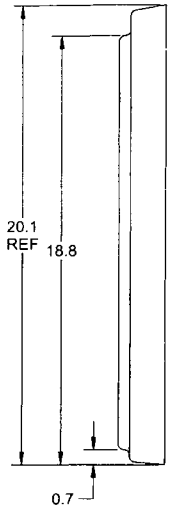
☐ Folio/Program
☐ Grain
☐ Hardware
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☐ Instructions Incomplete/Unclear
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☐ Out of Sequence

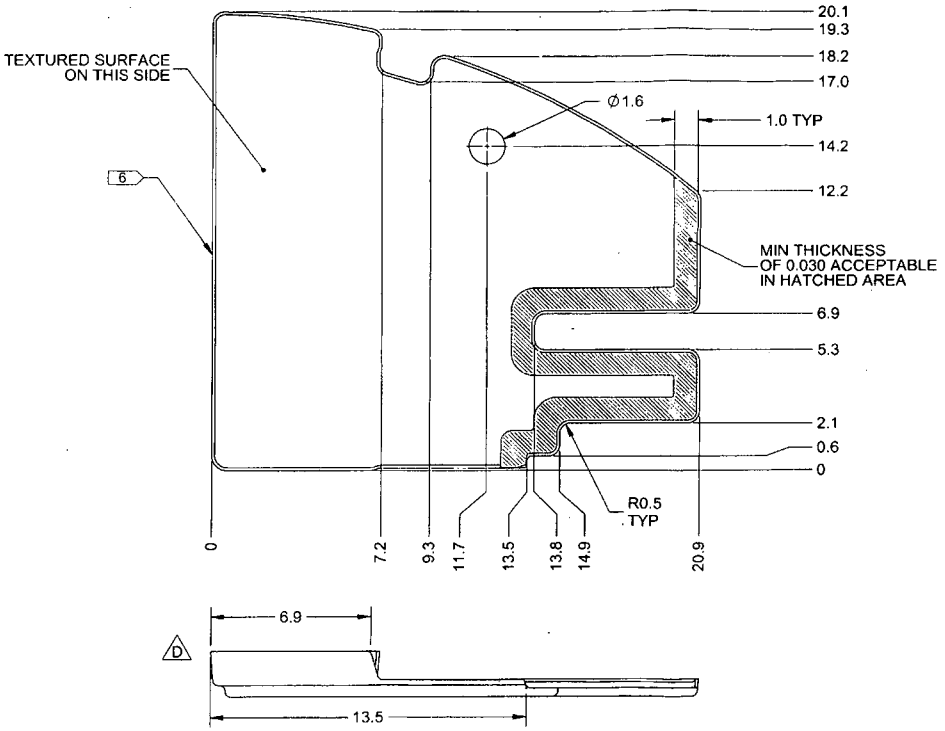
☐ Outside Dimensions
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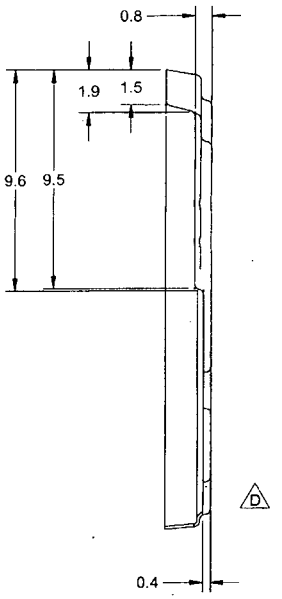
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☐ Weld
☐ Wrong Stock Pulled

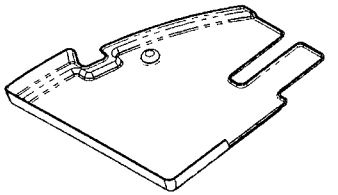
☐ Other _____











SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 125533 MLS
14-10-10

RELEASED
2014 -10- 08
MP

D4941-1LXX FWD LH FLOOR PROTECTOR

NOTES:
1) MATERIAL: SEE TABLE
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
7) WEIGHT: 1.5 lbs
8) THERMOFORM PER QSI 022 USING MOLD DT9990
TRIM PER MOLD LEAVING FINISHED EDGES
9) MINIMUM THICKNESS AFTER FORMING IS 0.070"

PART NUMBER	DESCRIPTION
D4941-1L02	F6006 SUEDE/POLISHED 701 BLACK LEXAN SHEET 0.125 THICK (REF DART SPEC MLEXS.125-F6006-02)
D4941-1L08	90318 PROTECT-A-GLAZE 112 CLEAR LEXAN SHEET 0.118 THICK (REF DART SPEC MLEXS.118-90318-08)

REV.	DESCRIPTION	BY	DATE
D	ADDED VIEWS (ZN C3-1, ZN D6-1, ZN A6-1). EDITED DETAIL D (ZN D2-2) AND DETAIL F (ZN B3-2). EDITED TRIM LOCATION ON D4941-2 (ZN B6-3). EDITED VIEW (ZN D6-3). ADDED VIEW (ZN A6-3). ADDED DETAIL H (ZN C2-3). REVISED D4941-3 AND D4941-4.	AK	14.07.25
C	EDITED TRIM LOCATION ON D4941-1 (ZN D8-2, ZN D6-2, ZN A6-2, ZN D2-2, ZN C1-2). ADDED A CUTOUT TO D4941-2LXX (ZN B6-3). REVISED D4941-4 TO REMOVE CUTOUT (ZN B8-5).	AK	14.06.16
B	REVISED OVERALL DIMENSIONS OF D4941-1/-2/-3/-4	AK	14.02.12
A	NEW ISSUE	AK	13.10.03

APPROVED

DESIGN	AK	DART AEROSPACE LTD
DRAWN	AK	HAWKESBURY, ONTARIO, CANADA
CHECKED	VS	DRAWING NO. D4941 REV. D
MFG. APPR.	DL	SHEET 1 OF 5
APPROVED	HS	TITLE CABIN FLOOR PROTECTORS
DE APPR.	DS	SCALE NTS
DATE	14.07.25	

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
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Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data	☐									
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Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
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FAULT CATEGORY

Landing Gear

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General

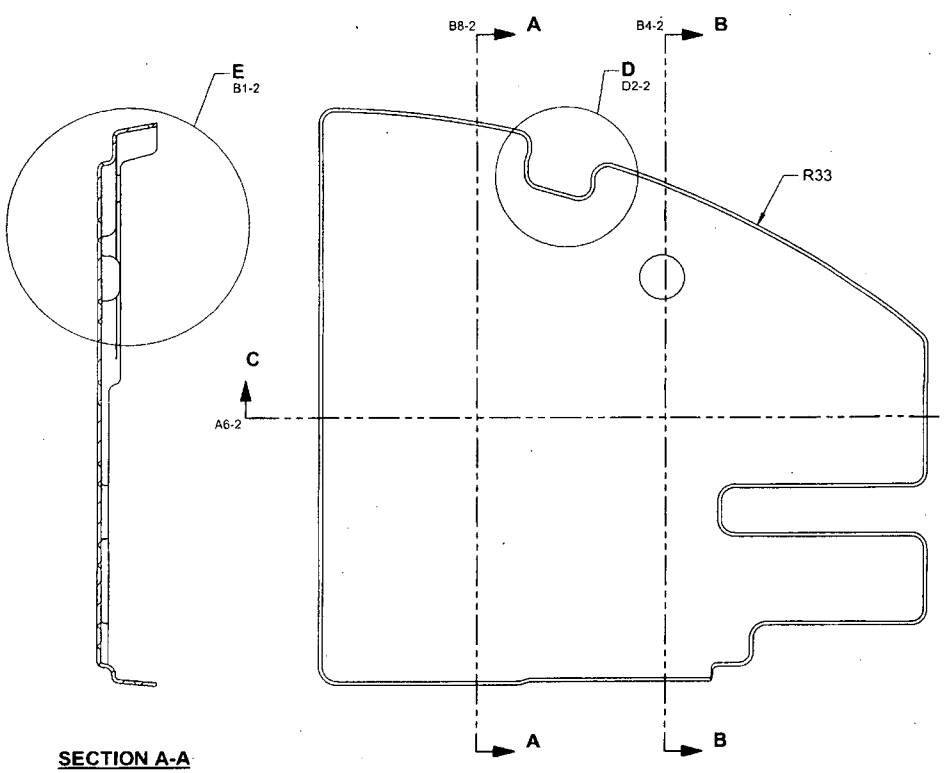
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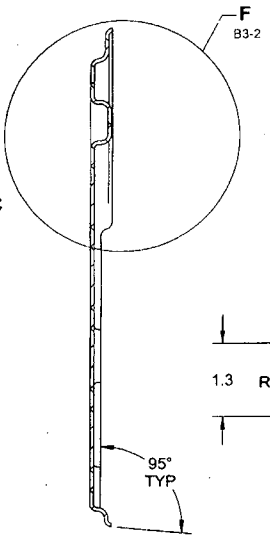
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☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

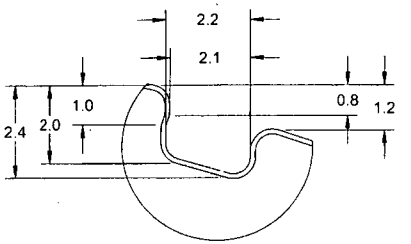
☐ Other



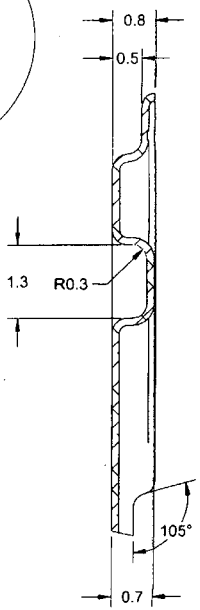
SECTION A-A
D6-2



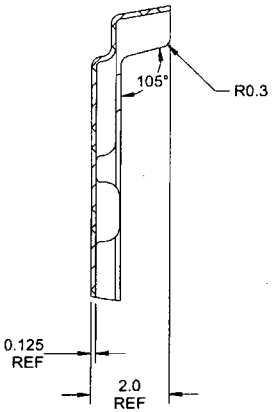
SECTION B-B
D5-2



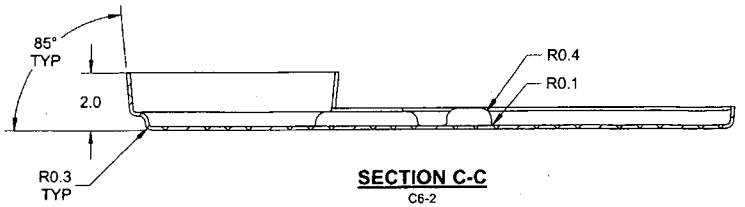
△D **DETAIL D**
D6-2



DETAIL F △D
D4-2



DETAIL E
D8-2



SECTION C-C
C6-2

RELEASED
2014-10-08

D4941-1LXX FWD LH FLOOR PROTECTOR

DESIGN	AK	**DART AEROSPACE LTD**
DRAWN	AK	HAWKESBURY, ONTARIO, CANADA
CHECKED	VS	DRAWING NO. D4941 — REV. D
MFG. APPR.	DL	SHEET 2 OF 5
APPROVED	HS	TITLE: CABIN FLOOR PROTECTORS — SCALE: NTS
DE APPR.	DS	
DATE	14.07.25	

APPROVED

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

